Work Order ID 123617 *123617* Page 1 Monday, August 18, 2014 2:34:51 PM Item ID: D3594-5 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Doubler *10* **Start Date:** 8/18/14 **Start Oty: 10.00 Cust Item ID:** Required Date: 8/18/14 Reg'd Oty: 10.00 *10* Customer: Reference: Run Start Process Plan: __M____ **Approvals:** Date: 14-08-19 Tooling: Date: Stop QC: Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code **Qty** Stamp Oty Number Draw Nbr **Revision Nbr** D3594 Rev B 100 0.00 FLOW WATER JET *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3594 6061-080 Dwg Rev: \mathcal{B} Prog Rev: B 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 (0) a/or 14/10/23 *110* OC 0.00 Memo Quality Control

DQA:			Date:				_			224				DART
QA Closed:			Date:			WORK ORDER NON-	·CC	ONFO	RMANCE / U		ork Order up	odate only	\neg	AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		· · · · · · · · · · · · · · · · · · ·
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						Rework			Skid-tube	Crosstube		Water Jet		Engineering
Part N	Ю.					Scrap			Machining	Small Fab	=4	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stoi	re/Packaging	\dashv	Other
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		Crushing				Countersink		Mislabe	ned/off center	<u> </u>	Power Loss/	r	\neg	Other
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		Inspection		equi	-	Drawing	 	Off-set						
		Marks/Ch				Drill Holes	<u> </u>	4	Calibration				—	
	<u> </u>	Turning S	-		<u> </u>	Finish	_	-						
	Wave/Twist in Tube				Fit/Function	L	Jour or s	Sequence						

Work Order ID 123617 *123617* Page 2 Monday, August 18, 2014 2:34:51 PM Item ID: D3594-5 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Doubler **Start Date:** 8/18/14 *10* **Start Oty: 10.00 Cust Item ID:** Required Date: 8/18/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Start Process Plan: Approvals: Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp 120 QC8- Inspect parts - second check 0.00 DAS *120* 38 OCT 2 4 2014 0.00 Memo Quality Control 130 0.00 Small Fab *130* 10x Small Fab 0.00 Memo Small Fab 1-C'SINK AS PER dwg d3594 DAS 140 QC5- Inspect part completeness to step on W/O 0.00 38 *140* 9-89

OCT 2 8 ZU14

0.00

QC

Quality Control

Memo

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						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	10.					Scrap			Machining	Small Fab	-	d. Eng. Coor.	Quality Other
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	_	Cracks				Broken/Damage/Defect	-	Hardwa		!:6:	Part Incorred	<u> </u>	Weld
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	-	Cuffs			-	Contamination	-	4	ions Incomplete/l	Inclear	Part Moved	Vrong.	TANIOUR STOCK Lauled
	Crushing Countersink			4	-	1	gned/off center	 	Positioned V Power Loss/		Other		
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		Marks/Ch				Drill Holes		Off-set					
Turning Sequence Finish			4	-	4	Calibration							
l	Wave/Twist in Tube			Fit/Function	L_	Out of	Sequence						

Work Order ID 123617 *123617* Page 3 Monday, August 18, 2014 2:34:51 PM Item ID: D3594-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Stop Doubler **Start Date:** 8/18/14 **Start Qty: 10.00** *10* **Cust Item ID:** Required Date: 8/18/14 Reg'd Otv: 10.00 *10* **Customer:** Reference: Run Start Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Qty Code Qty Number Stamp 150 Chemical Conversion Coat per QSI005 4.1 0.00 *150* HandFinish 0.00 Memo Hand Finishing 160 Inspect Part Finish 0.00 DAS *160* 10 38 9-89 QC Memo 0.00 OCT 2 8 2014 Quality Control Identify as per dwg & Stock Location 170 DAS 26 OCT 2 8 2014 *170*

0.00

Packaging

Packaging

Memo

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE							DART
QA Closed:			Date:								ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
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Root					Desci	ription of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
				<u> </u>			FAI	ULT CAT	EGORY				
Landir	Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Misread		· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	_	Marks/Ch					\vdash	Off-set	Calibration				
	Turning Sequence Finish Wave/Twist in Tube Fit/Function			4		4	Sequence						

Work Order ID 123617 *123617* Monday, August 18, 2014 2:34:51 PM Item ID: D3594-5 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Doubler **Start Date:** 8/18/14 **Start Qty: 10.00** *10* **Cust Item ID:** Required Date: 8/18/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Start **Approvals: Process Plan:** Date:_____ Tooling: Date: Stop QC: Date: SPC (Y/N): Date: *NR2* Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Accept Reject **Work Center ID Description Run Hours** Code Qty Qty Number Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

180

120

Quality Control

Page 4

Insp.

DQA:			. Date:			WORK ORDER NON-CONFORMANCE / UPDATE							
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	Inspection Strip in Tube		Drawing		Misread	d	_						
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	Turning Sequence			Finish		Out of 0	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of S	Sequence					

Picklist Print

Monday, August 18, 2014 2:34:50 PM

Work Order ID: 123617

D3594-5

Parent Item Name: Doubler

123617

D3594-5

Start Date: 8/18/14

Required Date: 8/18/14

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

Parent Item:

IPP Rev : A New Issue 08.07.07

EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6S.080		Purchased	No			100	sf	418.9760	0.055	0.578947	1			_
M6061 T6 6061-T6 .080 Sheet	SS 080								**		<u>.</u>	DC	14/10/	123

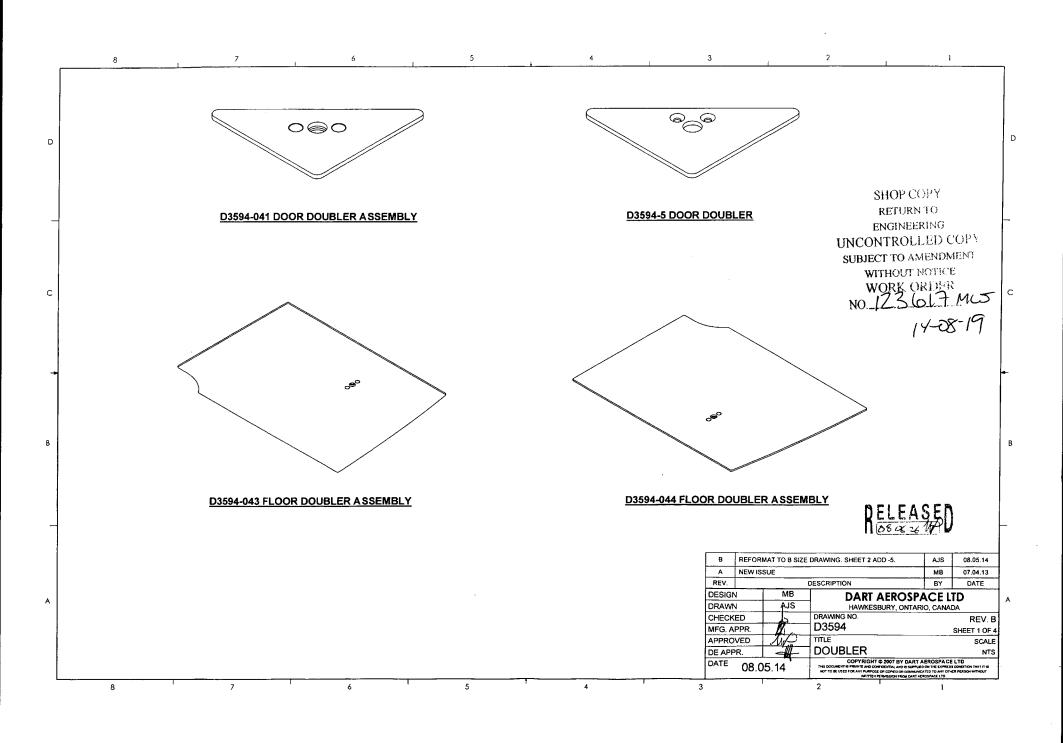
Location	Loc Oty	Loc Code	
MAT021	290.11		
m126309	130.52		 _
m126350	13.34		
m128903	146.25		
TPI	128.866		
m129439	128.866		
130560			. 6623

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						WORK ORDER NON-	·CC	ONFO	RMANCE / U		A / l - O l -		daka ambu. 🔽	AEROSPACE
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ı	Wave/Twist in Tube			1*										

DART AEROSPACE LTD	Work Order: [236]	
Description: Door Doubler	Part Number: D3594-5)
Inspection Dwg: D3594 Rev: B	Page 1 of	1

Inspection Dwg	<u> : D3594 </u>	/ : B				Pag	ge 1 of 1
	_	ST ARTICLE X First Art	_				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
Ø0.323	+0.006/-0.001	£.323	/		V=JkM-01		
Ø0.128	+0.005/-0.001	F. 128	1				· · · · · · · · · · · · · · · · · · ·
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1.000	+/-0.010	1.001					
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R0.13	+/-0.030	R .13	J				
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			DAS				
Measured by:	Dela,	Audited by:	38 9-89		Prototype A	Approval:	N/A
Date:	14/10/29	Date:				Date:	N/A
Rev Date	Change		OCT 2	4 2014	· · · · · · · · · · · · · · · · · · ·	Povised by	Annroyad
A OO OT 24	Manage		· · · · · · · · · · · · · · · · · · ·			Revised by	Approved

Rev	Date	Change	OCT <u>Z 4 ZUI</u> 4	Revised by	Approved
Α	08.07.24	New Issue		KJ/DD	3



2 3 QTY. PART NUMBER DESCRIPTION R0.13 TYP D3594-041 DOOR DOUBLER ASSEMBLY X DOOR DOUBLER D3594-1 0.530 MS21069L5 ANCHOR NUT RIVET, CSK 0.359 MS20426AD4-4 Ø0.128 THRU $\stackrel{\frown}{\otimes}$ Ø0.248 X 100° CSK D3594-1 DOOR DOUBLER 2 PL 1.000 Ø0.323 REF MS20426AD4-4 RIVET - 1.000 - - 2.57 2 PL Ø0.128 THRU Ø0.248 X 100° CSK -**D3594-1 DOOR DOUBLER** 2 PL 0.508 R0.13 REF TYP 0.359 2 PL 0.530 (\boxtimes) 45° 1.000 MS21069L5 ANCHOR NUT Ø0.323 REF 4 D3594-041 DOOR DOUBLER ASSEMBLY -- 1.000 — 2.57 NOTES:
1) MATERIAL: -1 & -5
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10 5 D3594-5 DOOR DOUBLER B DESIGN **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA

DRAWN AUS DRAWING NO. CHECKED D3594 MFG. APPR. 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED TITLE 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX 7) WEIGHT -041: 0.04 lbs APPROVED **DOUBLER** DE APPR. -5: 0.03 lbs DATE 08.05.14

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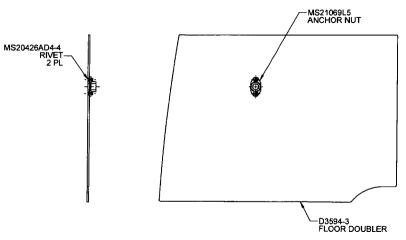
REV. B

SCALE

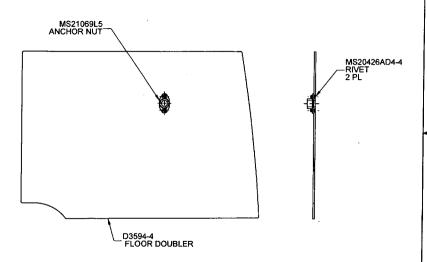
NTS

SHEET 2 OF 4

QTY. -044 QTY. -043 PART NUMBER DESCRIPTION D3594-043 FLOOR DOUBLER ASSEMBLY, LH X FLOOR DOUBLER ASSEMBLY, RH D3594-044 X D3594-3 FLOOR DOUBLER, LH D3594-4 FLOOR DOUBLER, RH MS21069L5 ANCHOR NUT RIVET, CSK MS20426AD4-4



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:
1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC, M6061T6S.080)
2) FINISH: CHÉMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	DART AEROS	PACE LTD			
DRAWN	AJS	HAWKESBURY, ONT	TARIO, CANADA			
CHECKED		DRAWING NO.	REV. B			
MFG. APPR.	77	D3594	SHEET 3 OF 4			
APPROVED	149	TITLE	SCALE			
DE APPR.	4	DOUBLER	NTS			
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